

Split

Date: Tuesday, 03/03/2009 4:15:28 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 46271 -2		
Estimate Number	: 10721		
P.O. Number	:	Part Number	: D34637
This Issue	: 03/03/2009 S.O. No. :	Drawing Number	: D3463 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B
Previous Run	: 46147	Material	:
Written By	:	Due Date	: 16/03/2009
Checked & Approved By	: <u>JULIE DAWSON</u>	Qty:	40 Um: EACH
Comment	: EST REV> A 05.11.18 new issue EC		
	Est Rev:B Added Step 7 08-11-04 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W120	304 ss round tube .750 x .120w
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40X

Comment: Qty.: 1.2243 f(s)/Unit Total: 48.9720 f(s)
 AISI 304 SS seamless tubing 0.750 OD X 0.120 wall
 (M304TR0750W120)
 Batch: M111096

m.d 09/03/12

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Cut to 13.875"
 2-Deburr

7 m.d 09/03/12

40X

3-Bend end as per dwg D3463

FF 09/03/12 40

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

0903.13 40

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 1-Mill as per dwg D3463

PTC

2-Drill hole & ream to 0.4385" as per dwg D3463

3-Deburr

A.A 09/03/14 36

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 46271

Part Number: D34637

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



36

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A

09/03/14

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 09/03/16

36

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



4X

Comment: SMALL & MEDIUM FAB RESOURCE 1
Grind .450" rad

mf

09/03/17

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/17 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: B 46154 - used on

EL

9-7-17

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/17

Comment: FINAL INSPECTION/W/O RELEASE

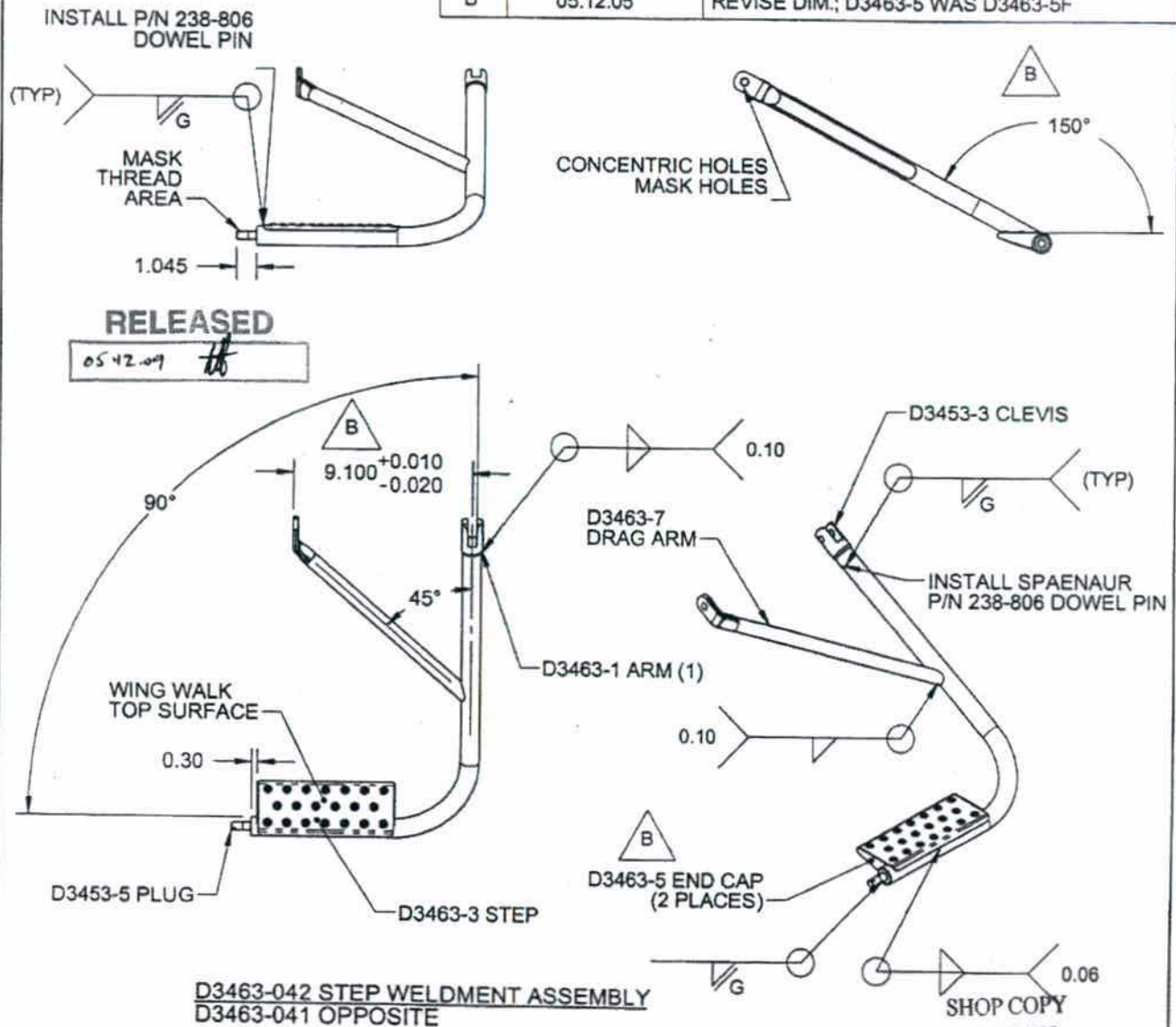
Job Completion



mf
09-03-17

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

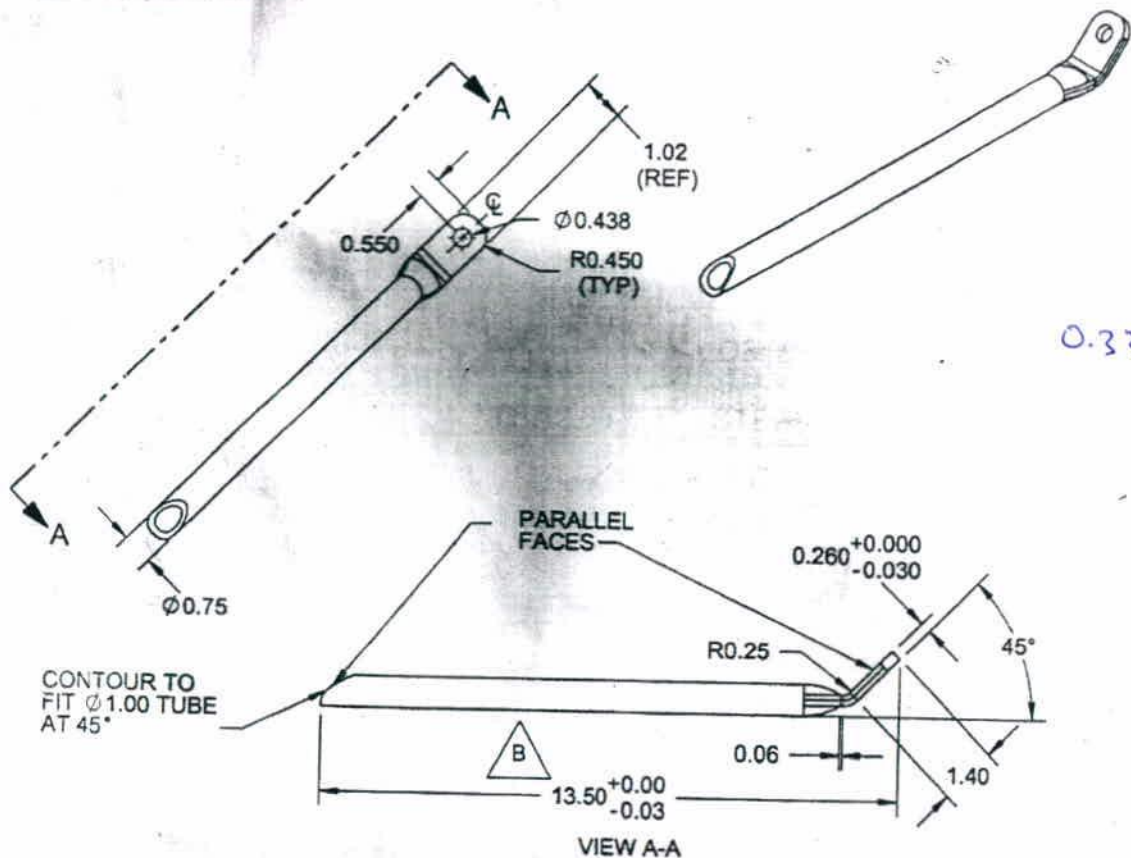
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED05.12.05 *[Signature]***D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304/304L 120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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